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British Standards Institution
Report

No. 98—1919.

British Engineering Standards Association.

(*Incorporated 1918.*)

FORMED IN 1901 AS THE ENGINEERING STANDARDS COMMITTEE
BY
THE INSTITUTION OF CIVIL ENGINEERS.
THE INSTITUTION OF MECHANICAL ENGINEERS.
THE INSTITUTION OF NAVAL ARCHITECTS.
THE IRON AND STEEL INSTITUTE.
THE INSTITUTION OF ELECTRICAL ENGINEERS.

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BRITISH
STANDARD SPECIFICATION
FOR
GOLIATH LAMP CAPS AND LAMP HOLDERS
FOR
CURRENTS UP TO 15 AMPERES OR POWERS UP TO 1000 WATTS
FOR

Pressures not exceeding 250 volts when the containing case is of metal only, or for pressures not exceeding 650 volts when the containing case is of porcelain or of metal with porcelain lining.

LONDON:
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December, 1919.

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NOTE.—*The Association desires to call attention to the fact that this Specification is intended to include the technical provisions necessary for the supply of the articles herein referred to, but does not purport to comprise all the necessary provisions of a Contract.*

BRITISH STANDARD SPECIFICATION FOR GOLIATH LAMP CAPS AND LAMP HOLDERS

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CURRENTS UP TO 15 AMPERES OR POWERS UP TO 1000 WATTS

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Pressures not exceeding 250 volts when the containing case is of metal only, or for pressures not exceeding 650 volts when the containing case is of porcelain or of metal with porcelain lining.

DEFINITIONS.

Lamp Cap.

1. The term "Lamp Cap" denotes the base attached to the lamp.

Socket Screw.

2. The term "Socket Screw" denotes the screwed tube in the holder.

SPECIFICATION FOR LAMP CAP.

Dielectric of Lamp Cap.

3. The dielectric of the Lamp Cap shall be of vitrite.

Form of Thread on Lamp Cap.

4. The form of the thread on the Lamp Cap shall be in accordance with Figure 1.

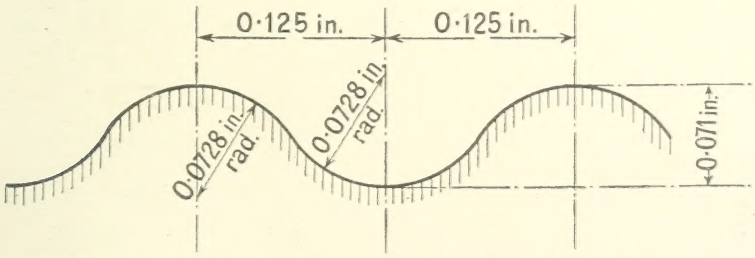

Fig. 1.—Form of Thread on Lamp Cap and Socket Screw.

Dimensions of Lamp Cap.

5. The screw thread on the Lamp Cap shall have a $\frac{1}{4}$ inch pitch, and shall have the dimensions given below :—

Dimensions of Screw Thread.	Maximum.	Minimum.
	Inches.	Inches.
Diameter at crest of thread ...	1·555	1·537
Diameter at root of thread ...	1·413	—
Length	—	1·024

The central contact shall have a maximum diameter of 0·709 inch ; and the distance between its face and the commencement of the outer threaded portion shall be within the limits of 0·354 inch and 0·315 inch.

Gauging of Lamp Cap.

6. The Lamp Cap shall be tested by means of the gauges shown in Figures 2 and 3 (*see Plates* 1 *and* 2). When the cap is screwed home into the "Go" gauge shown in Figure 2, the surface of the central contact shall be between the two outer surfaces **X** and **Y** of the plate (*see Appendix*), and the face at the end of the screw of the Lamp Cap shall come into contact with the inner face **Z** of the plate. The "Not Go" gauge (Figure 3) shall not pass over the screw thread.

SPECIFICATION FOR LAMP HOLDER.

Dielectric of Lamp Holder.

7. The dielectric shall be of porcelain or tough incombustible insulating material which will not soften when heated to a temperature of 200° C. (392° F.), and in either case after 24 hours immersion in water it shall not increase in weight more than one half per cent., after all moisture has been removed from the surface.

Material and Thickness of Socket Screw.

8. The Socket Screw shall be of copper and the thickness of any part shall be not less than 0·026 inch.

Form of Thread on Socket Screw.

9. The form of the thread on the Socket Screw shall be in accordance with Figure 1.

Dimensions of Socket Screw.

10. The screw thread on the Socket Screw shall have a $\frac{1}{4}$ inch pitch, and shall have the dimensions given below:—

Dimensions of Screw Thread.	Maximum.	Minimum.
	Inches.	Inches.
Diameter at crest of thread ...	1·435	1·417
Diameter at root of thread ...	—	1·559

The length of engagement between the threads on the Lamp Cap and the Socket Screw shall be not less than $\frac{7}{8}$ inch when the former is screwed home.

Central Contact of Lamp Holder.

11. The central contact of the lamp holder shall be concentric with the Socket Screw, and shall be so designed that a pressure of not less than seven pounds shall be exerted on the central contact of the lamp, when the lamp is screwed home; and this pressure shall be maintained after use.

Area of Central Contact of Lamp Holder.

12. The face of the central contact, which shall not be perforated, shall have an area of not less than 0 15 square inch, and the diameter, if circular, shall not exceed $\frac{5}{8}$ inch.

Gauging of Lamp Holder.

13. The Socket Screw and the central contact shall be tested by means of the gauges shown in Figures 4 and 5 (*see Plates 3 and 4*).

The "Go" gauge (Figure 4) shall be screwed into the holder until face **Z** is in line with the end of the screwed socket. If the end of the plunger, face **W**, project beyond face **X**, it shall be possible to push the plunger back by hand by means of pressure on the knob, until face **W** returns to face **X**. If face **W** does not project beyond face **X**, the gauge shall be screwed further into the holder, and face **W** shall reach face **V** before **Y** is forced below the end of the screwed socket.

The "Not Go" gauge (Figure 5) shall not enter the Socket Screw.

Terminals.

14. The terminals shall be of brass. They shall be of the pillar type and situated at the back of the holder. Provision shall be made for side entry clamping screws; and the thickness of the wall through which the clamping screw passes shall be not less than 0.080 inch.

The diameter of the wire holes shall be not less than 0.187 inch.

Terminal Clamping Screws.

15. The terminal clamping screws shall be of brass No. 3 B.A., with round or cheese heads, in accordance with B.S. Report No. 57, and shall be of sufficient length, under the head, to extend to the far side of the wire holes.

Connections between Contacts and Terminals.

16. The connections between the central and outer (socket screw) contacts and the corresponding terminals, at the back of the holder, shall each have a core diameter of not less than No. 3 B.A. screw thread (0.127 inch), or shall be metal of equal section; and the socket screw shall have one or more additional fixing screws.

Clearance between Metal Parts of Opposite Polarity.

17. The clearance in the lamp cap orifice between metal parts of opposite polarity, when a lamp is in position, shall be not less than $\frac{1}{4}$ inch.

Material and Thickness of Metal Case.

18. If a metal case be provided it shall be of copper, brass or other suitable metal. The minimum thickness of any unthreaded portion shall be 0·026 inch, and the thickness at the bottom of any threaded portion shall be not less than 0·020 inch.

Unlined Metal Case.

19. When an unlined metal case or cover is provided, it shall be fixed at least $\frac{1}{8}$ inch clear of any live metal parts, in the closest position they can take up.

Lock or Grip for the Lamp.

20. A lock or grip, not requiring a special form of lamp cap, and provided either with or without a separate release, shall be supplied to prevent the lamp from unscrewing owing to vibration.

Nipple.

21. The diameter of the nipple shall be not less than $1\frac{1}{16}$ inches, and it shall be screwed $\frac{3}{4}$ inch conduit thread, which shall comply in all respects with the requirements of the screw threads and gauges given in B.S. Report No. 31. A side clamping screw, or other means, shall be provided for securing the nipple to the conduit. This requirement shall not prevent the use of cord grips or nipples screwed for special purposes when required.

NOTE.—It is recommended that the lanterns used with these lamp holders should be ventilated.

APPENDIX.

NOTES ON THE GAUGES.

"Go" Gauge for Thread on Lamp Cap (*Plate* 1, *Figure* 2).

In order to reduce difficulties of manufacture this gauge is built up of several parts.

Part of the plate is cut away to facilitate the viewing of the lamp cap when in the gauge.

"Not Go" Gauge for top of Thread on Lamp Cap (*Plate* 2, *Figure* 3).

This is a ring "Not Go" gauge to ensure that the crest diameter of the screw thread is not less than the minimum called for.

"Go" Gauge for Thread on Lamp Holder and position of Central Contact (*Plate* 3, *Figure* 4).

This gauge tests the diameter and pitch of the screw thread in the lamp holder, and the position of the central contact of the lamp holder, and also ensures that the pressure of the contact is not less than seven pounds when the lamp is screwed home.

"Not Go" Gauge for Core Diameter of Thread on Lamp Holder (*Plate* 4, *Figure* 5).

This is a simple plug "Not Go" gauge. The sides of the cylinder are cleared to enable the gauge to enter a lamp holder, if too large, in which a spring projects in the socket screw.

MATERIAL FOR THE GAUGES.

The gauges should be made of steel with the gauging surfaces hardened.

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GAUGES FOR LAMP CAP.

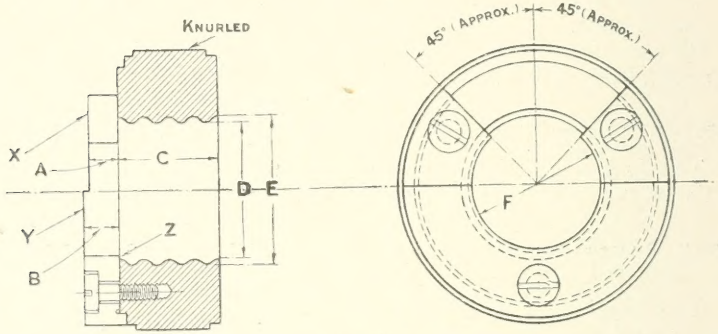

Fig. 2.—"Go" Gauge for Lamp Cap.

TABLE I.

Dimensions of "Go" Gauge for Lamp Cap.

Reference Letter.	Dimension.	Tolerance.
	Inches.	Inch.
A	0·3150	+ 0·0000 − 0·0005
B	0·3540	+ 0·0005 − 0·0000
C	1·024	+ 0·000 − 0·001
D	1·413	+ 0·001 − 0·000
E	1·555	+ 0·001 − 0·000
F (dia.)	1·200	± 0·001

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GAUGES FOR LAMP CAP.

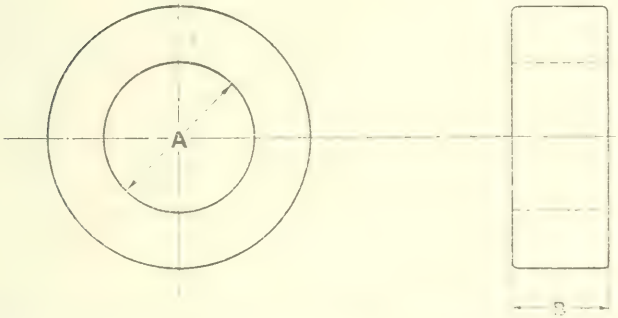

Fig. 3.—"Not Go" Gauge for Crest of Thread on Lamp Cap.

TABLE II.

Dimensions of "Not Go" Gauge for Crest of Thread on Lamp Cap.

Reference Letter.	Dimension.	Tolerance.
	Inches.	Inch.
A	1·5370	$\left.\begin{matrix} + \\ - \end{matrix}\right\}$ 0·0000 0·0005
B	1·0	—

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GAUGES FOR LAMP HOLDER.

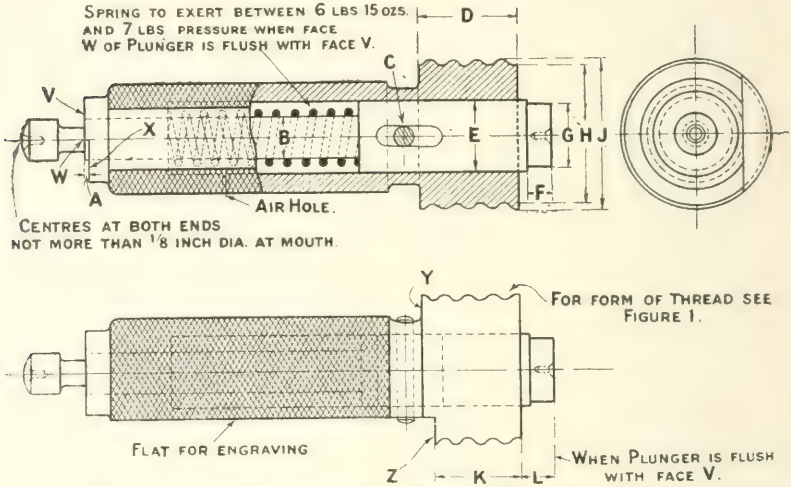

Fig. 4.—"Go" Gauge for Thread on Lamp Holder and position of Central Contact.

TABLE III.

Dimensions of "Go" Gauge for Thread on Lamp Holder and position of Central Contact.

Reference Letter.	Dimension.	Tolerance.
	Inches.	Inch.
A	0·039	+ 0·001 / − 0·000
B (dia.)	7/16	—
C (pin.)	3/16	
D	1·025	± 0·001
E (dia.)	3/4	—
F	1/4	
G (dia.)	11/16	—
H	1·417	+ 0·000 / − 0·001
J	1·559	+ 0·000 / − 0·001
K	0·874	± 0·001
L	0·315	+ 0·000 / − 0·001

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GAUGES FOR LAMP HOLDER.

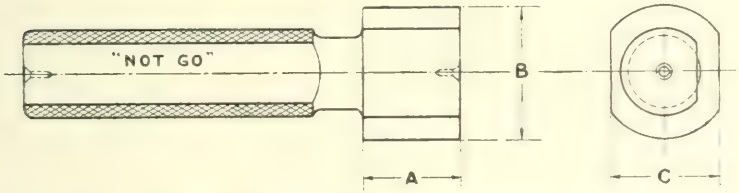

Fig. 5.—"Not Go" Gauge for Core Diameter of Thread in Lamp Holder.

TABLE IV.

Dimensions of "Not Go" Gauge for Core Diameter of Thread in Lamp Holder.

Reference Letter.	Dimension.	Tolerance.
	Inches.	Inch.
A	1·0	—
B (dia.)	1·4350	$\begin{cases} + \ 0{\cdot}0005 \\ - \ 0{\cdot}0000 \end{cases}$
C	$1\frac{1}{2}$	—

TABLE V.

Dimensions of "Go" Gauge for Screw in Nipple of Lamp Holder.

—	Dimension.	Tolerance.
	Inch.	Inch.
Full diameter . .	0·7500	$\begin{cases} + \ 0{\cdot}0000 \\ - \ 0{\cdot}0006 \end{cases}$
Effective diameter .	0·7100	$\begin{cases} + \ 0{\cdot}0000 \\ - \ 0{\cdot}0006 \end{cases}$
Core diameter . .	0·6700	$\begin{cases} + \ 0{\cdot}0000 \\ - \ 0{\cdot}0009 \end{cases}$
Length of Screwed part	$\frac{5}{8}$ (approx.)	
Pitch of Screw. .	16 threads per inch.	

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DECEMBER, 1919.

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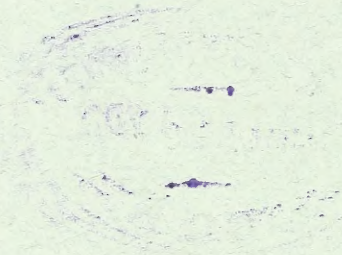
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